Technical Data Sheet

technicoll® 8153
Contact adhesive for rigid foam material of PS (polystyrene)

Field of application

Bonding of PS – rigid foams and insulation materials, such as mineral or glass fibre mats with metal, bituminised felts, aluminum and different kinds of unplasticised polymeric films.

Special characteristics

technicoll® 8153 is a fast setting, unfilled contact adhesive with a high resistance to water and heat.

Data of handling and product

Base	styrene-butadiene rubber (SBR)
Viscosity (+20 °C)	approx. 1800 mPas
Solid content	approx. 36 %
Density	approx. 0.8 g/cm³
Colour	brownish - transparent
Drying time	1 to 3 minutes
Contact life	approx. 10 to 15 minutes (depending on temperature, substrate and quantity of adhesive)
Way of application	two-sided
Processing temperature	+15 °C to +25 °C
Consumption	150 - 250 g/m²
Dilution	not necessary, possible with technicoll® 8363
Cleaning agent / material	technicoll® 8363 technicoll® 9901 (metal cleaning spray) technicoll® 9902 (plastics cleaning spray)
Cleaning agent / tool	technicoll® 8363, technicoll® 9901 (spray)
Cleaning	Cured adhesive can only be removed mechanically.
Maximum time of storage	At least 1 year when stored in sealed original packaging in cool and dry places.
Preferred storage temperature	+15 °C to +25 °C
Behaviour at low temperature	Not susceptible to frost. Densification at low temperature. Once adjusted to processing temperature: fully employable.

Favoured substrates

● polystyrene rigid foam (PS, EPS, XPS)		● metals
● Styropor®, Styrodur®		● bituminised felt
● glass fibre mats	with:	● concrete, render
● felt		● aluminum foil
● mineral fibre mats		● derived timber products
		● plastic films (unplasticised)

Not suitable for: PE, PP, PTFE (Teflon®), POM, silicone, EPDM, PVC plasticised (faux leather)

Due to the large variety of possible materials and differences in adhesion behaviour hazard tests are mandatory before introducing the adhesive into the actual production process.

Surface preparation

Bonding surfaces must be dry and clean, especially free of oil, grease or release agents. In many cases, surface roughening prior to bonding improves strength of bonded joint. It is recommended when working with rubber and metals.

Adhesion

Stir adhesive before use. Apply a thin layer of technicoll® 8153 equally to both sides of the bonding surface of the substrates (brush, trowel, closed roller). After the application solvent needs to evaporate. The usual waiting time is just a few minutes. It depends on the applied amount of adhesive and the indoor climate. The right time for the bonding has come as soon as the applied adhesive does not pull strings anymore when touching with the finger, but still feels very sticky. Join the substrates together accurately and assemble quickly under high pressure. The good bond strength that is achieved immediately, usually allows further processing with the bonded substances right away.
In some cases a one-sided application might be possible: Apply a thick layer of technicoll® 8153 equally to one side and join both surfaces immediately.
Wait for a couple of days before assessing the final strength.

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